

Work Order ID 59142

Wednesday, May 26, 2010 3:11:10 PM



Page 1

Item ID: D3572-3

Accept



Setup Start



Revision ID:

Item Name: Guide

Stop



Start Date: 5/26/2010

Start Qty: 30.00 50



Cust Item ID:

Required Date: 6/4/2010

Req'd Qty: 30.00 50



Customer:

Reference:

Approvals:

Process Plan: H

Date: 10-5-24

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3572

Rev D

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank .500" long

STP
10/05/31

30 ✓
+ 20 mm 10/06/02

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA685 Rev: C & Dwg D3572 Rev: RA ☐ 2-Debur
per dwg D3572

mm
10/05/02

STP
10/05/03

51 ✓

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

mm
10/05/02

STP
10/05/03

51 ✓

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 59142

Wednesday, May 26, 2010 3:11:10 PM

Page 2

Item ID: D3572-3

Accept

Revision ID:

Item Name: Guide

Start Date: 5/26/2010 Start Qty: 30.00

Required Date: 6/4/2010 Req'd Qty: 30.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: *w/4*

0.00



Packaging

Memo

0.00

Packaging

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*10/06/04**ME**10-6-3*

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NOTE: Date & initial all entries

Picklist Print

Wednesday, May 26, 2010 3:11:14 PM

Page 1

Work Order ID: 59142

Parent Item: D3572-3

Parent Item Name: Guide

Comments: IPP Rev:A New Issue 07-02-07 JLM
IPP rev B rev.B dwg EC

Start Date: 5/26/2010

Required Date: 6/4/2010

Start Qty: 30.00

Required Qty: 30.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6B0.750X01.50 0 | | Purchased | No | | | | f | 6.9260 | 0.04 | 1.200600 | | | |

6061-T6 Bar .750 X 1.50

Location

MAT

114415

Loc Qty

6.926

6.926

Loc Code

1,25(F)
+ .8750
mjt 10/05/02

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NOTE: Date & initial all entries

Dart Aerospace Ltd

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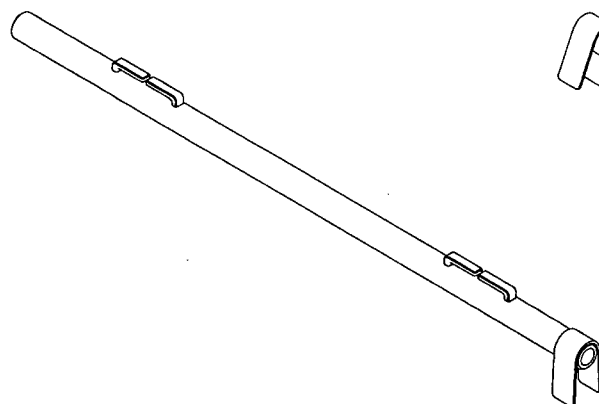
NOTE: Date & initial all entries

| ITEM No. | QTY -041 | QTY -043 | QTY -044 | PART NUMBER | DESCRIPTION |
|----------|----------|----------|----------|-------------|-----------------------------|
| 1 | X | | | D3572-041 | GUIDE ASSEMBLY |
| 2 | | X | | D3572-043 | GUIDE ASSEMBLY (UH-1) |
| 3 | | | X | D3572-044 | GUIDE ASSEMBLY (UH-1) (OPP) |
| 11 | 1 | 1 | 1 | D3572-1 | TUBE |
| 12 | 4 | 4 | 4 | D3572-3 | GUIDE |
| 13 | 1 | 3 | 3 | D3572-5 | BRACKET |
| 14 | - | - | - | D3572-7 | DELETED AT REV C |

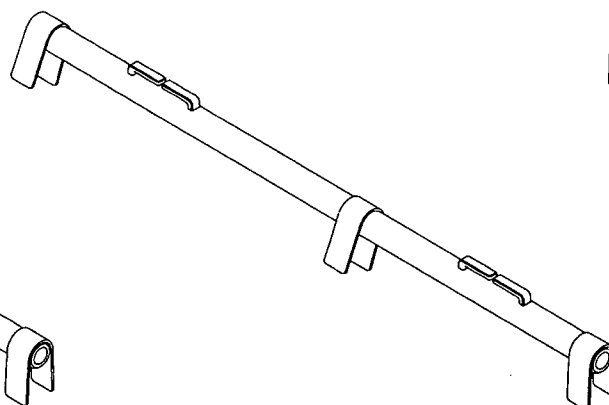
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED CO.
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 59142

10-5-26

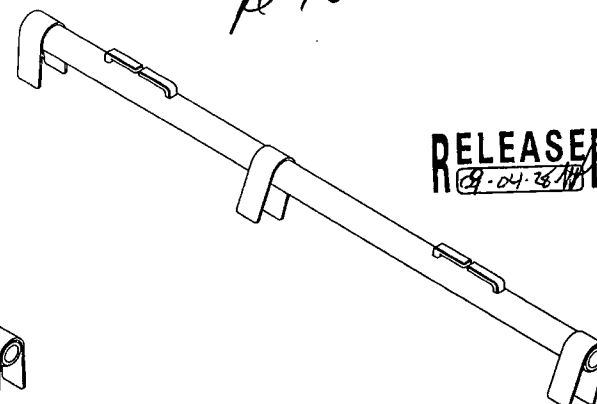
RELEASED
09-04-26/17



D3572-041 GUIDE ASSEMBLY



D3572-043 GUIDE ASSEMBLY (UH-1)



D3572-044 GUIDE ASSEMBLY (UH-1)

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3572-XXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.34 lbs
-043/-044: 1.42 lbs
- 8) WELDING: PER DART QSI 004

| | | | |
|------------|---|--|--------------|
| D | REDRAWN IN "B" SIZE FORMAT TO CURRENT STANDARDS. ADD -043, -044 FOR UH-1. SEE PAR 09-017. | AJS | 09.04.17 |
| C | REMOVE D3572-7 | LE | 07.06.01 |
| B | FOR D3573-3 0.03 CHMF WAS 0.06; ADD TYP TO FILLET | LE | 07.04.20 |
| A | NEW ISSUE | LE | 07.03.29 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | LE | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. D |
| MFG. APPR. | <i>[Signature]</i> | D3572 | SHEET 1 OF 4 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | GUIDE ASSEMBLY | NTS |
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NOTE: Date & initial all entries

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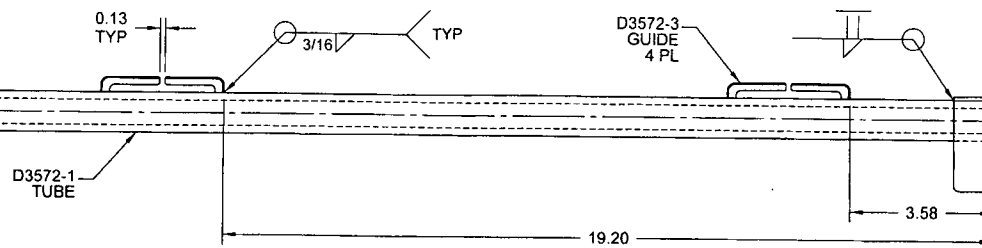
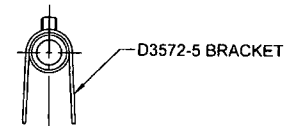
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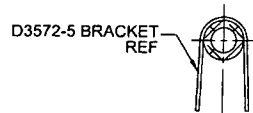
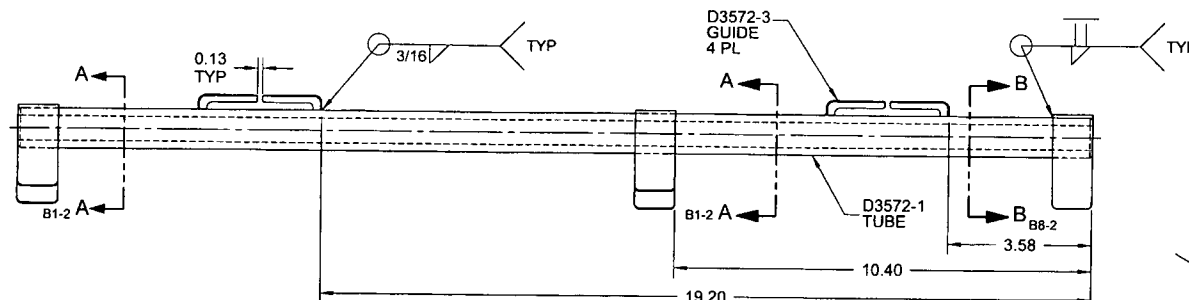
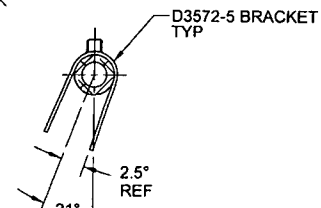
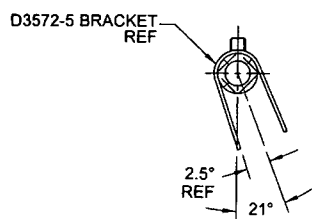
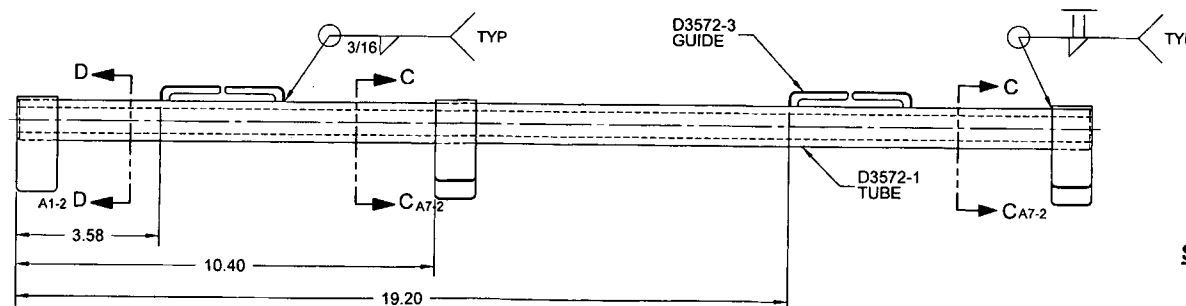
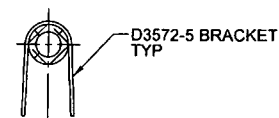
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1

**D3572-041 GUIDE ASSEMBLY**

D3572-5 BRACKET

**SECTION B-B** C2-2**D3572-043 GUIDE ASSEMBLY****SECTION A-A** C7-2
(2 PL) C4-2**RELEASED**
09.04.17**SECTION C-C** A2-2
A5-2**D3572-044 GUIDE ASSEMBLY****SECTION D-D** A7-2

| | | | |
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| DESIGN | LE | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | A.S. | | |
| CHECKED | J.B. | DRAWING NO. | REV. D |
| MFG. APPR. | E. | D3572 | SHEET 2 OF 4 |
| APPROVED | H. | TITLE | SCALE |
| DE APPR. | H. | GUIDE ASSEMBLY | NTS |
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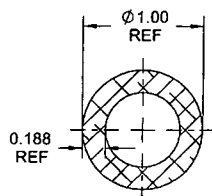
| W/O: | | WORK ORDER CHANGES | | | | | |
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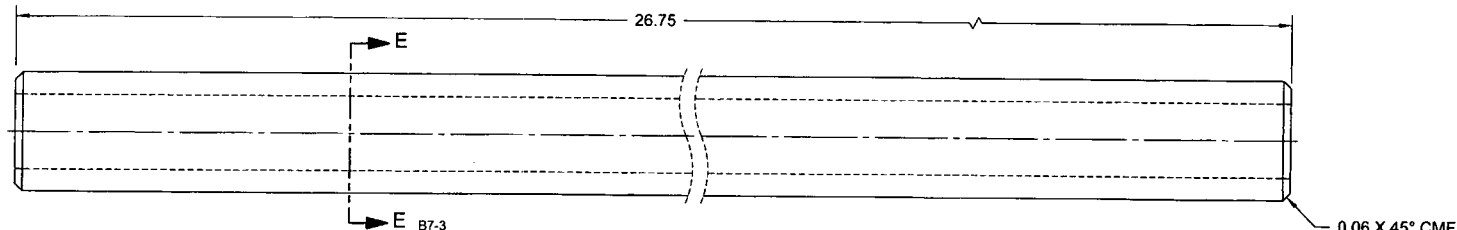
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NOTE: Date & initial all entries



SECTION E-E C5-3



D3572-1 TUBE

D3572-1 NOTES:

- 1) MATERIAL: 6061-T6 (T62) ALUMINUM TUBE 1.00 OD X 0.188 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR AMS-QQ-A-200/8 OR AMS-QQ-A-225/8
REF DART SPEC M6061T61.000W.188
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.25 lbs

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| DESIGN | LE | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | | |
| CHECKED | JS | DRAWING NO. | REV. D |
| MFG. APPR. | JS | D3572 | SHEET 3 OF 4 |
| APPROVED | JS | TITLE | SCALE |
| DE APPR. | JS | GUIDE ASSEMBLY | NTS |
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09/04/17 MP

W659142

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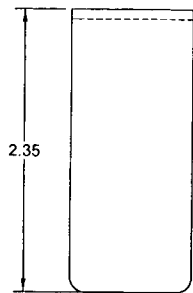
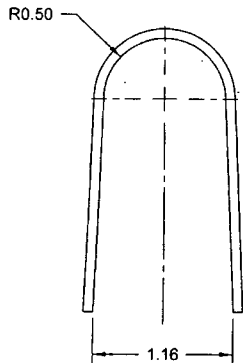
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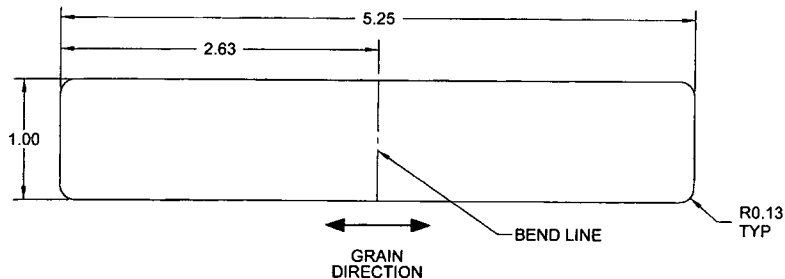
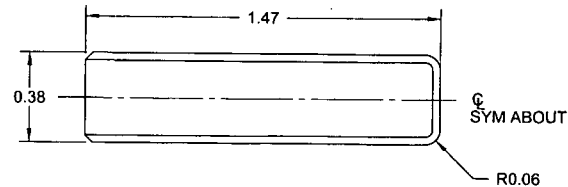
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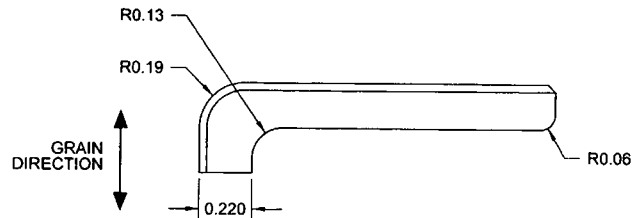
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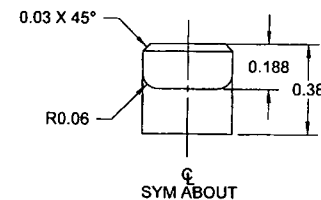
D3572-5 BRACKET
(MAKE FROM D3572-5F)



D3572-5F FLAT PATTERN



D3572-3 GUIDE



W/S 59142

RELEASED
9/04/17

D3572-3 NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T651/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
AMS-QQ-A-200/8 (OR AMS4160)
REF DART SPEC M6061T6B
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

D3572-5 NOTES:

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M60601T6S.080
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

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| DESIGN | LE | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AS | | |
| CHECKED | | DRAWING NO. | REV. D |
| MFG. APPR. | | D3572 | SHEET 4 OF 4 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | GUIDE ASSEMBLY | NTS |
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